

Work Order ID 80259-1

80259

Page 1

February-15-12 3:34:19 PM

split 1

Item ID: D3560-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

**10* 94*
**10* 94*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *HLJ*

Date: *12/02/16* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3560	Rev D								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

and 12/03/09

10 10

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA693 Rev: *HL* & Dwg D3560 Rev: *D*
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

12-3-12 10 4

12-03-15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12-3-12 10 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80259***80259***

Page 2

February-15-12 3:34:19 PM

Item ID: D3560-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm Weldment
Start Date: 15/02/2012 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 29/02/2012 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 12/03/16		10	0		
140 *140* Large Fab Large Fab	Large Fab Memo 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end) Alu Rod # 123528	0.00 0.00				4	0		13.02.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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February-15-12 3:34:19 PM

80259

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/02/2012 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

150

QC	Memo	0.00
----	------	------

Quality Control

160	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

160

QC	Memo	0.00
----	------	------

Quality Control

170	Chemical Conversion Coat per QSI005 4.1	0.00
-----	---	------

170

HandFinish	Memo	0.00
------------	------	------

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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February-15-12 3:34:19 PM

Item ID: D3560-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Weldment
 Start Date: 15/02/2012 Start Qty: 10.00 *10*
 Required Date: 29/02/2012 Req'd Qty: 10.00 *10*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC1- Inspect Part Finish Memo	0.00 0.00				4x			EB 3/02/12
190 *190* Small Fab Small Fab	Small Fab Memo I-Press bushing in D3560 arm per dwg D3562	0.00 0.00				4x			EB 3/02/12
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			13227

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item ID: D3560-041 Accept *N900040100* Setup Start *NS1*
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 Item Name: Arm Weldment
 Start Date: 15/02/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>WMA</i>	0.00				<i>4</i>	<i>0</i>		<i>13-02-28</i>
210									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL ***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

13/3/4
ME
13-3-1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-15-12 3:34:23 PM

Page 1

Work Order ID: 80259

80259

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

70.0000

1

10

D2808

Bushing

**

Location

Loc Qty

Loc Code

GA

70

32896

2

76188

3

78950

24

79688

41

M6061T6B0.500X05.00
0

Purchased

No

140

f

51.2274

1.395

14.68421

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

29.3934

120243

24

→ 120421

5.3934

M120866

X12

2.8

of 12/03/09

8/13/02/27
385479 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-15-12 3:34:23 PM

Page 2

Work Order ID: 80259

80259

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

D3592-1

Manufactured No

190

Each

27.0000

1

10

D3592-1

**

13.02.19

Plate

Location

Loc Qty

Loc Code

WA

B82022

4

78934

4

WA002

23

47015

2

78934

21

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80259-1
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

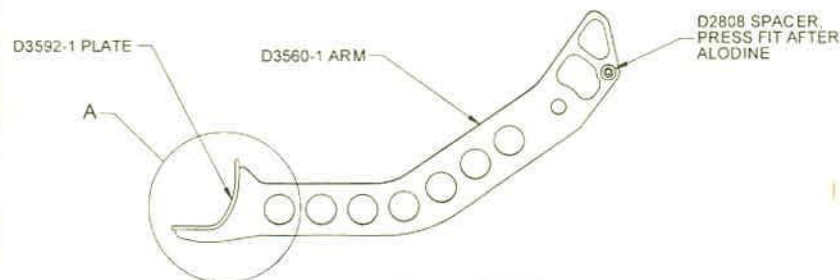
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5070	-			
Ø0.196	+0.005/-0.001	.196	-			
Ø1.000	+0.010/-0.001	1.004	-			
0.500	+/-0.010	.496	-			
0.250	+/-0.010	.249	-			
0.275	+/-0.010	.274	-			
0.188	+/-0.010	.190	-			
2.000	+/-0.010	2.000	-			
1.700	+/-0.010	1.700	-			
Ø0.385 x 100°	+/-0.010 x 0.5°	.385 x 100°	-			
0.250 Deep	+/-0.010	.252	-			

Measured by: <i>DR</i>	Audited by: <i>DA</i>	Prototype Approval:	N/A
Date: 12-3-15	Date: 12/03/16	Date:	N/A

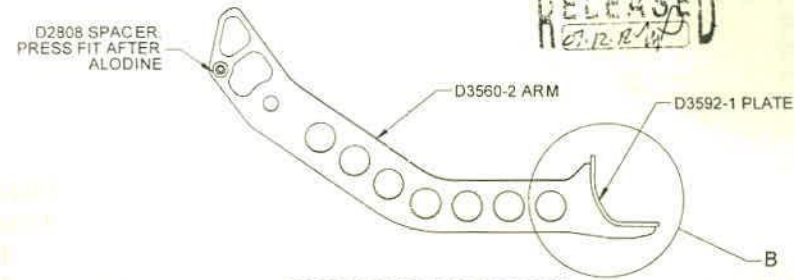
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	<i>DA</i>

LEI 39A

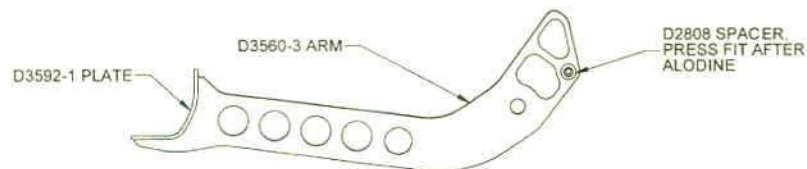
RELEASED
07.12.16



D3560-041 ARM WELDMENT



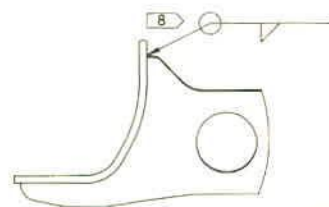
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1:2**

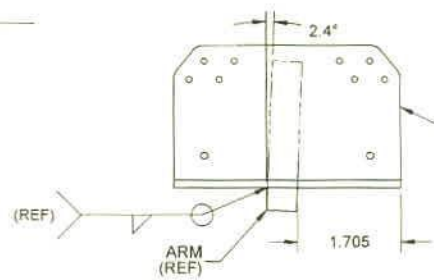
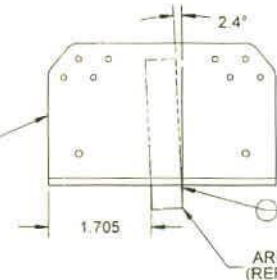


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

DESIGN	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG APPR.	NEW ISSUE	CP	06.09.25
APPROVED	REV.	DESCRIPTION	BY DATE
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D SHEET 1 OF 5
TITLE ARM WELDMENT	
SCALE 1:4	
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- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

UNCONTROLLED
SUBJECT TO REVISION
WITHIN 1000
WEEKS
NO. 80259 M.C.J
12/02/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

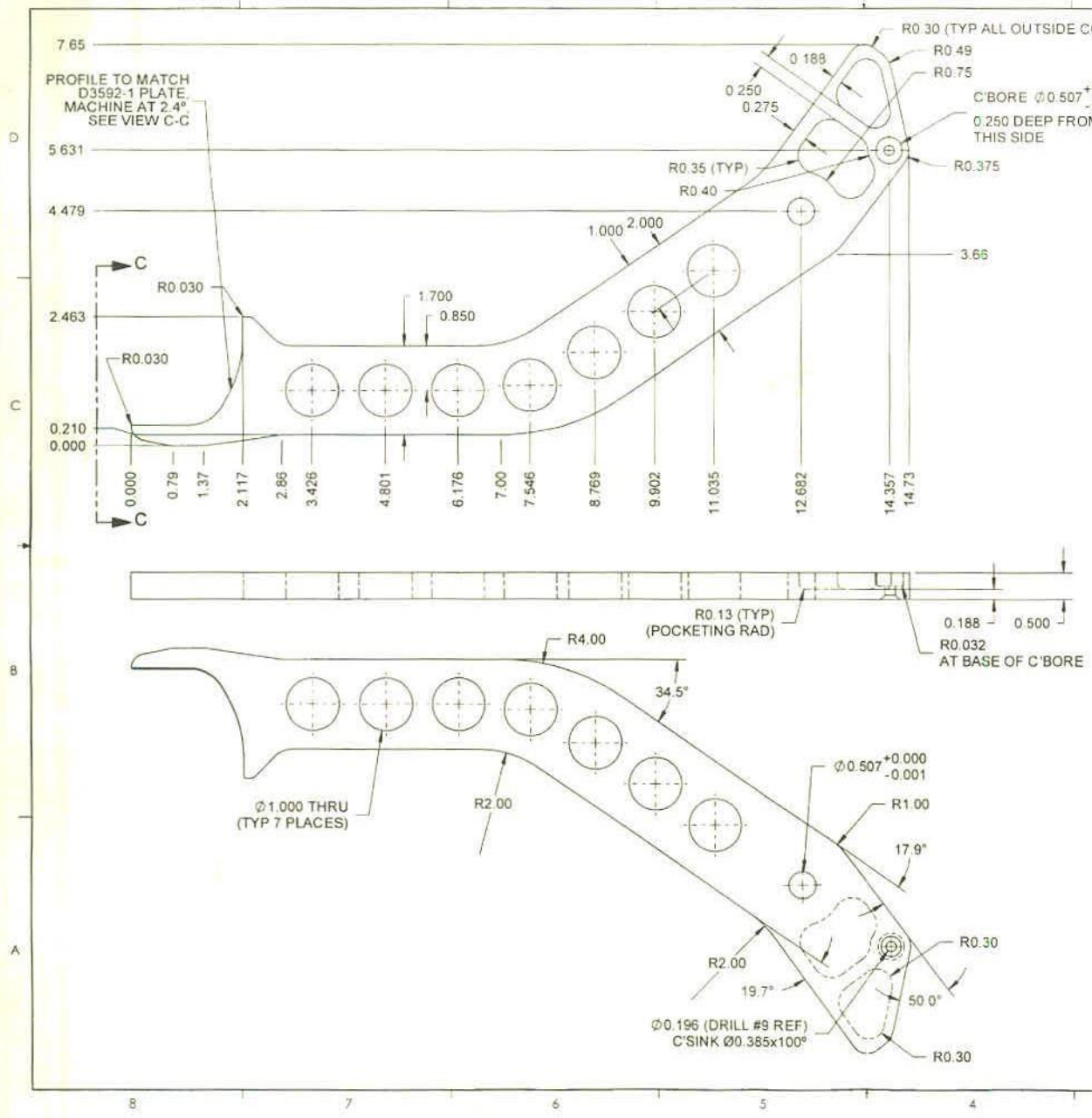
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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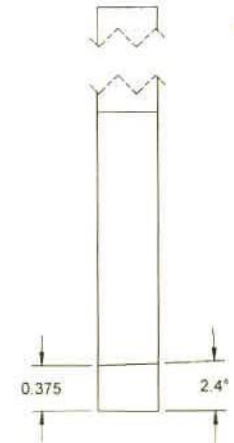
NOTE: Date & initial all entries

80259



D3560-1 ARM WELDMENT

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF: DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN	g	DART AEROSPACE LTD	
DRAWN	dc	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
07.12.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

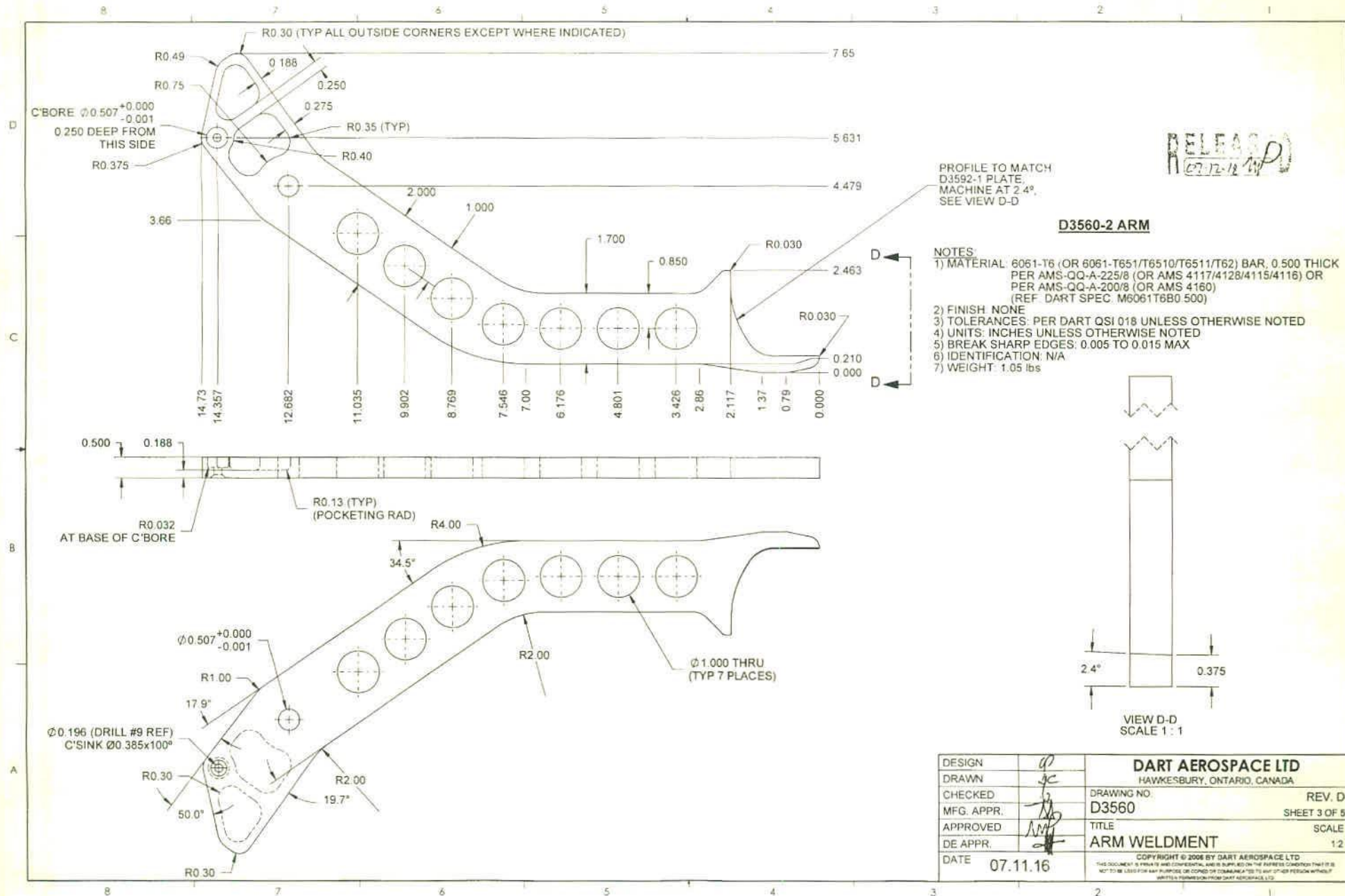
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Dart Aerospace Ltd

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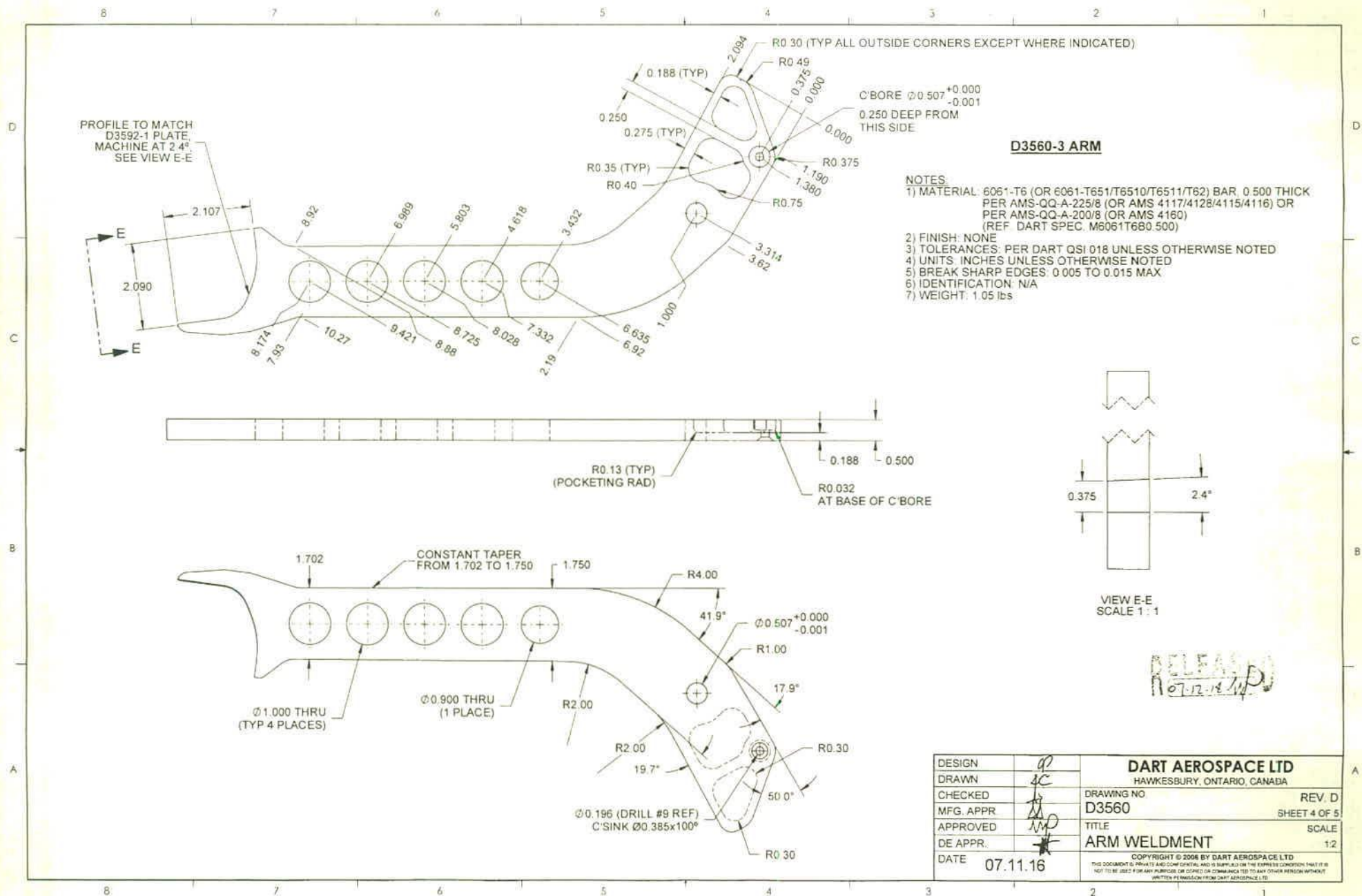
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NOTE: Date & initial all entries

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Dart Aerospace Ltd

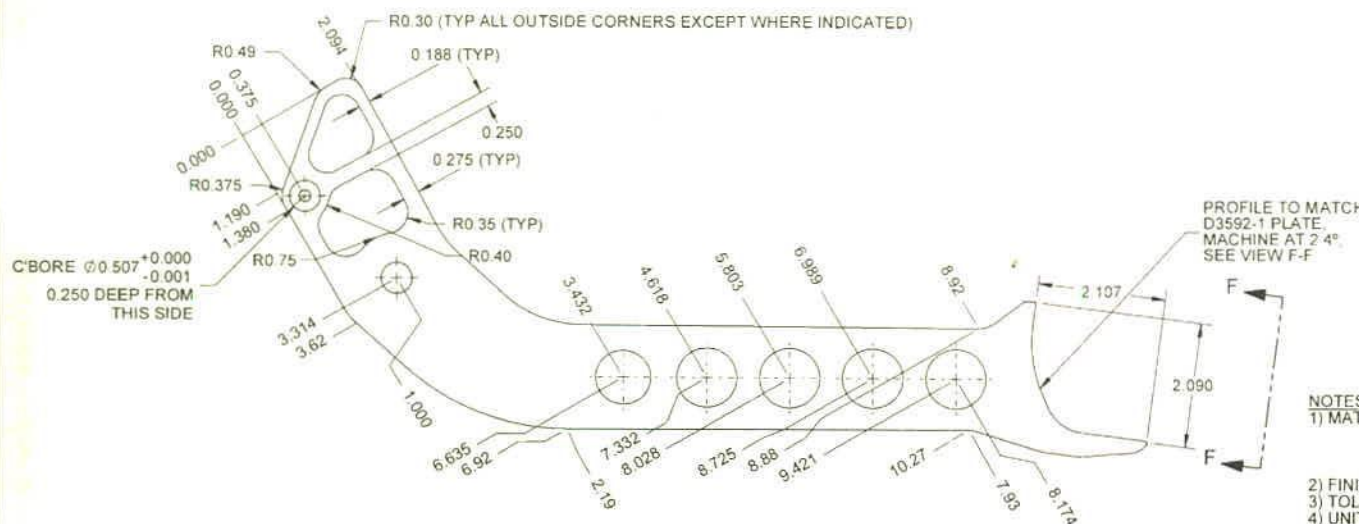
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NOTE: Date & initial all entries



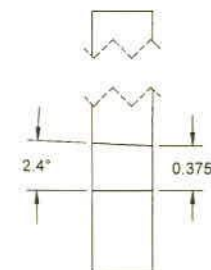
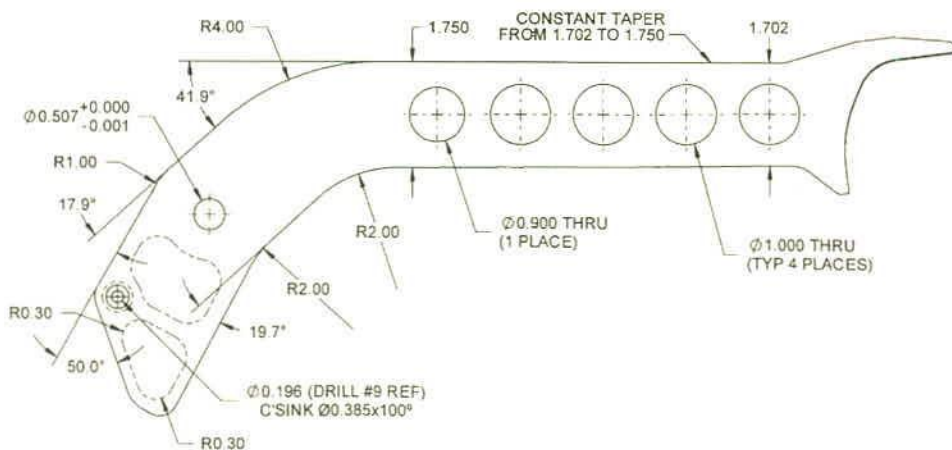
D3560-4 ARM

NOTES

- NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061TB0.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs



R0.032
AT BASE OF C'BORE



VIEW F-F
SCALE 1 : 1

07-12-18 *11/18*

DESIGN	<i>PC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D3560 TITLE ARM WELDMENT COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>"THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD."</small>	REV. D
DRAWN	<i>PC</i>		SHEET 5 OF 5
CHECKED	<i>PC</i>		SCALE
MFG APPR	<i>PC</i>		
APPROVED	<i>PC</i>		
DE APPR	<i>PC</i>		
DATE	07.11.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries